



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3910

Job Sheet 200596



Part No: 646.3910

Job Qty: 30 pcs

Part Name: Shim



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV nc1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
110	Waterjet - Flow - 1	30 pcs	10/4/19	10/4/19	0.01	0.72	Waterjet - Flow	9/13/19 JRB
120	QC 2	30 pcs	10/4/19	10/4/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	
							QC 2 - 65	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 613 632-5200
E-mail: sales@dartaero.com
www.dartaero.com



Container No: S218108

Part: 646.3910

Job No: 200596

Serial No/Batch: S218108

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/23/19

Plex 9/13/19 7:08 AM Dart.lajeunesse.marie

130	QC 8	30 pcs	10/4/19	0.00	0.00	QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	JRB 9/29/19
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	SEP 30 2019 40
						QC 8 - 52	9-89
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
140	Outsource - 3 - Cadplate	30 pcs	10/4/19			GRO002-VC	10 2019-10-01
150	Packaging 2-1 - Recelve - B4B	30 pcs	10/4/19	0.00	0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	OCT 11 2019
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
160	QC 6	30 pcs	10/4/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	DAS 81 9-89 OCT 11 2019
					QC 6 - 81	
170	Packaging 3-1 - Stock - B4B	30 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS 74 9-89 OCT 15 2019
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180	QC 21 - SA	30 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	OCT 15 2019 DAS 70 9-89
					QC 21 - SA - 53	

Part Op 110 - (Waterjet - Flow) 1-Cut as per Dwg
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O: 44643 Cad Platting, CAD PLATE PER QQ-P-416, TYPE II, CLASS 2, CL2
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 160 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P#

AND REV***

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MC1095S.020	C1095 Blue Tempered Spring Steel Sheet .020	.9000 sf (.03 ea)	110-Waterjet - Flow - 1	S142237

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	MC1095S.020	1	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	1.570Inches $\pm$ 0.005	1.575 1.565	1.573	
2	Shim	2.900Inches $\pm$ 0.005	2.905 2.895	2.900	
3	Shim	0.020Inches $\pm$ 0.005	0.025 0.015	0.020	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS							
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS042)								
Description Work Order Deviation		Disposition										
		Completed By										
		Lead hand / Supervisor										
		QC / QA Coordinator										
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY										
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐				



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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044643



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044643

PO Date: 10/1/19

Due Date: 10/9/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

REVISED

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201258	646.3912	Shim : Various STC's (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O: Cad Plating, CAD PLATE PER QQ- P-416, TYPE II, CLASS 2, CL2	Firmed X30	-	10/9/19	30 pcs	0 pcs	30 pcs	\$4.314452/pcs	\$129.43

Line Item Note: Proceed on removal of rust on parts, by passing a scuff pad and proceed with cad-plate.

60.00\$ for scuffing and 87.50\$ strip charge fee, is included in pricing per unit

200597	Firmed	-	10/9/19	45 pcs	0 pcs	45 pcs	\$4.314452/pcs	\$194.15
Sub Total:				75	0	75		\$323.58

2	200596	646.3910	Shim : Various STC's (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O: Cad Plating, CAD PLATE PER QQ- P-416, TYPE II, CLASS 2, CL2	Firmed X49	-	10/9/19	49 pcs	0 pcs	49 pcs	\$4.314452/pcs	\$211.41
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Line Item Note: Proceed on removal of rust on parts, by passing a scuff pad and proceed with cad-plate.

60.00\$ for scuffing and 87.50\$ strip charge fee, is included in pricing per unit



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PURCHASE ORDER

POHB044643



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	200598	646.3913	Shim : Various STC's Issue P/O: Cad Plating, CAD PLATE PER QQ- P-416, TYPE II, CLASS 2, CL2	Firmed X21	-	10/9/19	21 pcs	0 pcs	21 pcs	\$4.314452/pcs	\$90.60
Line Item Note: Proceed on removal of rust on parts, by passing a scuff pad and proceed with cad-plate. 60.00\$ for scuffing and 87.50\$ strip charge fee, is included in pricing per unit											
4	201058	RBT400280	Hanger Simulator -Issue P/O: -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Material type; A36 -Certificate of Conformity is required ***Part must be stripped and re plated.***	Firmed X1	-	10/9/19	1 pcs	0 pcs	1 pcs	\$4.314452/pcs	\$4.31
Grand Total:										\$629.91	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/11/19 8:26 AM Dart.Lavoie.Chantal

10/1/2019

PURCHASE ORDER

22897/5

DART
AEROSPACEDart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

OCT. 2019

PURCHASE ORDER
POHB044643**Supplier:** GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3868
Fax: 514-335-3868**Attention:** Grenon, Sylvie**Ship To:** 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200**PO No:** POHB044643**PO Date:** 10/1/19**Due Date:** 10/9/19**Purchase Order****Revision:****Revision Date:****Ship-To Contact:** Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com**Via:** Ground**Pymt Terms:** Net 60**Freight Terms:****Special Comments:**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201258	646.3912	Shim : Various STC's (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O: _____ Cat Plating, CAD PLATE PER QQ-P- 416, TYPE II, CLASS 2, CL2 <i>Yvelon</i>	Firmed	-	10/9/19	30 pcs	0 pcs	30 pcs	\$0.10/pcs 2.97	\$3.00
	200597			Firmed	-	10/9/19	45 pcs	0 pcs	45 pcs	\$0.10/pcs	\$4.50
Sub Total:							75	0	75		\$7.50
2	200596	646.3910	Shim : Various STC's (Outsource process- Cadplate per QSI017 4.1.9.1) Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P- 416, TYPE II, CLASS 2, CL2	Firmed	-	10/9/19	49 pcs	0 pcs	49 pcs	\$0.10/pcs \$3.71	\$4.90
3	200598	646.3913	Shim : Various STC's Issue P/O: _____ Cad Plating, CAD PLATE PER QQ-P- 416, TYPE II, CLASS 2, CL2	Firmed	-	10/9/19	21 pcs	0 pcs	21 pcs	\$0.10/pcs 2.97	\$2.10

Plex 10/1/19 8:42 AM Dart.Guerin.Kimberley

10/1/2019

PURCHASE ORDER



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044643



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	201058	RBT400280	Hanger Simulator -Issue P/O; -Cadmium plating, QQ-P-416F TYPE II, CLASS II -Color; Yellow -Material type; A36 -Certificate of Conformity is required ***Part must be stripped and re plated.***	Firmed	-	10/9/19	1 pcs	0 pcs	1 pcs	\$0.10/pcs \$15.50	\$0.10
Grand Total:											\$14.60

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/1/19 8:42 AM Dart.Guerin.Kimberley

SANBLASTING CHARGE - \$60

STRIP CHARGE - \$87.50

CONTRACT REVIEW	
☒	MANPOWER / TRAINING
☒	MATERIALS / TEST TAP
☒	LOGISTICS / CAPABILITIES
☒	ACQUISITION
9/10/19	



Certificat de Conformité / Certificate of Compliance

(022897-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022897 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
10-Oct-2019		Jigar Patel				POHB044643				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	646.3912 Rev.	646.3912 GLASS BEAD FIRST CAD YELLOW 500 [CADMIUM YELLOW 500] PLATE PER QQ-P-416 TYPE 2 CLASS 2 BAKE AFTER		CADMIUM CH	75	75	0	0	0	
2	646.3910 SHIM Rev.	646.3910 SHIM GLASS BEAD FIRST CAD YELLOW 500 [CADMIUM YELLOW 500] PLATE PER QQ-P-416 TYPE 2 CLASS 2 BAKE AFTER		CADMIUM CH	49	49	0	0	0	
3	646.3913 Rev.	646.3913 GLASS BEAD FIRST CAD YELLOW 500 [CADMIUM YELLOW 500] PLATE PER QQ-P-416 TYPE 2 CLASS 2 BAKE AFTER		CADMIUM CH	21	21	0	0	0	
4	RBT400280 Rev.	RBT400280 STRIP 01 - CAD YELLOW 500 [CADMIUM YELLOW 500] QQ-P-416F TYPE 2, CLASS 2 MATERIAL: A36		CADMIUM CH	1	1	0	0	0	
5	SCUFF PAD CHARGE Rev.	SCUFF PAD CHARGE 01 -CLEANING SCUFF PAD CHARGE		GENERAL MIN-CHG	1	1	0	0	0	
6	STRIP CHARGE Rev.	STRIP CHARGE STRIPPING CHARGES		STRIP CH	1	1	0	0	0	

RECEIVED
OCT 10 2019
DART AEROSPACE LTD.

RECEIVED
 OCT 10 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.